Work Order ID 89156 *89156* Page 1 August-21-12 3:04:39 PM Item ID: D412-705-015 Accept *N900040100* Setup Start **Revision ID: Item Name:** Driveshaft Tunnel Modification Start Qty: 1.00 **Start Date:** 8/21/12 **Cust Item ID:** Req'd Qty: 1.00 Required Date: 9/07/12 **Customer:** Reference: Run Process Plan: MCJ Date: 12/08/29 Approvals: Date: Stop SPC (Y/N): Date:_ Date: Reject Reject Sequence ID/ **Operation** Set Up/ **Tool ID** Tool # Plan Accept Insp. Work Center ID Qty Description **Run Hours** Code Qty Number Stamp **Draw Nbr Revision Nbr** Rev C N/A 100 0.00 DOCUMENT CONTROL *100* DC 0.00 Memo Document Control Photocopy bluefile & type labels per PPP D412-705-015 110 Pick Kit 0.00 *110* Packaging 0.00 Memo Packaging QC4-100% Inspect kits for completeness 0.00 120 *120* QC Memo

Quality Control

												DQA:	Date	e: <u>•</u>	<u> </u>
NCR:	Yes	/ No					WORK ORDER NON-CONFORMANCE / UPDATE						D-4-		•
						-			QA Closed: Date:						
Vork Order: DISPOSITI											AGAINST DE	PARTMENT	/PROCESS		
Part No.					Rework Scrap		Skid-tube Crosstube Machining Small Fab			Water Jet Prod. Eng. Coor.			Quality Quality		
NCR	No.						Use-as-is Work Order Update			Large Fab	Finishing Composite	Rec/Store/Packaging Oth Supplier			Other
Root					Des	crip	otion of work order update	1	nitial	Ac	tion	Sign &			
Cause		Date	Step	Qty		C	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	Q	C Inspector
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Land	ing (Gear Bending			1		General Bend	_	Grain			Ovalized	Г	Press	ure/Forced
		Centre No	ot Concer	ntric to (D/S		BOM/Route		Hardwa	re		Over/Under	tolerance		erature/Cure
		Cracks			·		Broken/Damaged		Inspect	on Incomplete		Part Incorre	ct	Weld	
	L	Crushed/	Crimped,				Burrs		Instruct	ions Incomplete/	/Unclear	Part Lost/M	issing	Wron	g Stock Pulled
	\perp	Cuffs					Contamination		Mainte	nance		Part Moved			
		Heat Trea	it				Countersink		Mislabe	led		Positioned V	Wrong _		
		Inspection	n Strip in	Tube			Cut Too Short		Misread	i		Power Loss/	'Surge	Othe	<u>r</u>
		Ripples in	Bend				Drill Holes		Offset			_			
		Torque W	aves in E	xtrusion	า	Γ	Drawing		Out of	Calibration					
	Г	Turning Sequence Finish					Out of Sequence								

Outside Dimensions

Wave/Twist in Tube

Folio

Work Order ID 89156 *89156* Page 2 August-21-12 3:04:39 PM Item ID: D412-705-015 Accept *N900040100* Setup Start Revision ID: Stop Item Name: Driveshaft Tunnel Modification Start Qty: 1.00 **Start Date:** 8/21/12 **Cust Item ID:** Required Date: 9/07/12 **Req'd Qty:** 1.00 **Customer:** Reference: Run Date: Tooling: **Approvals:** Process Plan: Date: Stop SPC (Y/N): Date: QC: Date: Sequence ID/ Reject Operation **Tool ID** Tool # Plan Set Up/ Accept Reject Insp. **Run Hours** Qty Qty **Work Center ID** Description Code Number Stamp 130 0.00 Packaging *130* Packaging 0.00 Memo Identify and pack for shipping as per PPP D412-705-Packaging PPP Rev: Suits 0.00 140 QC21- Final Inspection - Work Order Release

0.00

Memo

140

Quality Control

QC

MLJ 12-09-25 MX 09-25

										DQA:	Date:	***
NCR: Y	es /	/ No				WORK ORDER NON-C	CONFORM	MANCE / UP		QA Closed:	Date:	•
Work Order:						DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
Part No. NCR No.						Rework Scrap Use-as-is Work Order Update]	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
D = 1	-				Danasi		(misia)		tion	Cian 9		
Root Cause		Date	Step	Qty		ption of work order update or Non-conformance	Initial Chief Eng	t .	ction cription	Sign & Date	Verification	QC Inspector
Doc/Data		Date	эсер	Qty	•	or ton comormance	Chief Eng	Desc	. Tiperon	Dute	Vermedien	Q0 mspector
Equip/Tooling	\dashv											
Operator	\exists											
Material												•
Setup												
Other								1				
Process												
Supplier												
Training												

FAULT CATEGORY

Grain

Hardware

Maintenance

Out of Calibration

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

Ovalized

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Over/Under tolerance

Pressure/Forced

Weld

Other

Temperature/Cure

Wrong Stock Pulled

Turning Sequence Finish Out of Sequence
Wave/Twist in Tube Folio Outside Dimensions

General

Bend

Burrs

BOM/Route

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Broken/Damaged

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Ripples in Bend

Unapproved

Landing Gear

Bending

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

122151

122416

No

No

Manufactured

Manufactured

D3256-1 Panel D3256-3

 Location
 Loc Qty
 Loc Code

 ST176
 2

 66792
 1

 85708
 1

1102

Each

Each

0.0000

2.0000

120

120

B89125

Page 1

Status

12/9/25

										DQA:	Date	:
NCR:	Yes / No				WORK ORDER NON-C	100	VFORM	MANCE / UPDATE		QA Closed:	Date	•
:	.									QA Closed.	Date	•
Work Ord	er:				DISPOSITION			AGAINS	T DE	PARTMENT	PROCESS	
					Rework	1		Skid-tube Crosstube		1	Water Jet	Engineering
Part 1	No.				Scrap		*	Machining Small Fal	-	Prod	d. Eng. Coor.	Quality
					Use-as-is	1		noforming Finishin		-₹	e/Packaging	Other
NCR I	No				Work Order Update			Large Fab Composite	`—		Supplier	
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l andi			·			AUL	T CATE	GORY				
Langi	ng Gear Bending				General		٠:.		_	٦		٦
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	l lucar us	aı		- 1	Legantersink	Mislabe	iea	Positioned V				

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Picklist Print
August-21-12 3:04:38 PM

August-21-12 3:04	:38 PM								
Work Order ID:	89156								
Parent Item:	D412-705-015					Start	Date: 8/21/12	Required Da	ite: 9/07/12
Parent Item Name:	Driveshaft Tunnel Modification					Start	t Qty: 1.00	↑ Required Q	ty: 1.00
MS20427M3-3 Rivet	Purchased	No		120	Each	1,077.0000	Constitution of the second	e#4	
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d			ST318	3					/ \
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MS21060-L3K	Purchased	No		120	Each	183.0000	22	22	
Nut Plate								- M122 81	4 04
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			120142	95					
			ST319	88					
1			122141	88			14)	∠ '.	^
MS9321-09 3 Washer	Purchased	No		120	Each	655.0000	25	of \$ las	42
-			Location	Loc Qty		Loc Code			
			ST296	655					
			119546	50			-		
			120142	2					
	•		121524	103			7 6	•	
			122141	500			<u> </u>		
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										DQA:	:ı	Date:	•
NCR: Y	Yes / No)			WORK ORDER NON-C	100	NFORI	MANCE / UPDATE		QA Closed:	· r	Date:	•
Work Orde	r				DISPOSITION			AGAINST	DI	DEPARTMENT			
TAOIR OIGE	···			<u> </u>	Rework	1	1	Skid tubo	Г	٦	\A/a+=1	-t] ===:
Part N	10				Scrap	1		Skid-tube Crosstube Machining Small Fab		Prc	Water Je od. Eng. Coo		Engineering Quality
NCR No.					Use-as-is Work Order Update		1	noforming Finishing Large Fab Composite	Rec/Stc	ore/Packagin Supplie	· · ·	Other	
Root				Descrip	ption of work order update	Ti	Initial	Action		Sign &	T		
Cause	Date	Step	Qty			Chi	nief Eng	i		Date	Verificat	ion	QC Inspect
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L	Cracks				Broken/Damaged		Inspection Incomplete			Part Incorre	ect		Weld
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	Cuffs				Contamination	Maintenance				Part Moved	_	_	-
Ī	Heat Tr	eat			Countersink	Mislabeled				Positioned V	Wrong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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Change Record

Part Number <u>D412-705-015</u>
Description <u>DRIVESHAFT TUNNEL HODIFICATION</u> KIT

Page _ _ _ of _ _ _

Chg.	Date	By _	Relevant Documents PA-D4(2-105 Rev. B
100	04.04.12	K).4	011-04(5-108 17EN. B
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02	05.06.30	T* 1/1	PER DSI-9306 REV. A
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003	07.10.24	1	DR-D412-705 Rev. F
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REFERENCE ONLY

5.0 PARTS LIST

Qty -011	Qty -013	Qty \-015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
	-013	f-0 12	-017	-013	-021	-023	D412-705-011	TWIN PAK E-Z ACCESS KIT
X		-					D412-705-011	INTAKE PLENUM ACCESS PANEL KIT
1	Х			-	 		D412-705-015	DRIVESHAFT TUNNEL MODIFICATION KIT
1		Х	; -		<u> </u>		D412-705-015	N1 GEARBOX ACCESS PANEL KIT
1			Х		ļ			C-BOX OIL COOLER LINE SUPPORT ACCESS KIT
1				Х			D412-705-019	
1					X		D412-705-021	OIL PRESSURE TRANSMITTER ACCESS KIT
1						Х	D412-705-023	OIL COOLER SUPPORT REMOVABLE LOWER PANEL KIT
	1						D3245-041	ACCESS PANEL ASSEMBLY, LH
	1						D3245-042	ACCESS PANEL ASSEMBLY, RH
	2						D3245-043	DOOR ASSEMBLY
	2						D3245-9	GASKET
	2						D3245-11	GASKET
	2						D3245-13	GASKET
			1				D3255-041	ACCESS PANEL ASSEMBLY, LH
			1				D3255-042	ACCESS PANEL ASSEMBLY, RH
	-	77					D3256-1 /	ACCESS PANEL
	,	1					_D3256-3	GASKET
				1			D3259-041	ACCESS PANEL ASSEMBLY, LH
		1		1			D3259-042	ACCESS PANEL ASSEMBLY, RH
					1		D3307-041	ACCESS PANEL ASSEMBLY
		<u> </u>				30	AN3-3A	BOLT
		/22	30		6		AN3C-3A	BOLT
	 	43-					AN3G-4A	BOLT
	 				 	30	AN960JD10	WASHER
	16	<u> </u>	36		12		MS20427M3-3 2	RIVET
						2	_MS2 <u>1051-L3K</u>	NUT PLATE
	8	L 22-	18		_6		MS21060-L3K /	NUT PLATE
	1					18	MS21069-L3K	NUT PLATE
		/25	30		6		MS9321-09/	WASHER